

# Work Order ID 53248

October 28, 2009 1:50:58 PM

D-REV



Page 1

Item ID: PB67-43001-51 B 54774 Accept

Revision ID: C

Item Name: Long T-Handle Assembly

Start Date: 10/29/2009 Start Qty: 1.00

Required Date: 11/16/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: JMF Date: 09-10-28 Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001	C

100 Weld per dwg A/R Aluminum rod Batch: H111385 0.00  
Large Fab

Large Fab

Large Fab

Memo 0.00

- 1- drill #40 hole in center of -91 before welding -93 caps, to let air out
- 2- weld -93 to -91 as per dwg
- 3- grind weld flush
- 4- assemble -87 under the pilot hole in -91 and weld as per dwg

SP 09 12 15 (1x)

110  
QC

Quality Control

QC5- Inspect part completeness to step on W/O 0.00

Memo 0.00

→ 80, 12/15

(+)

120  
QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo 0.00

PD 09.12.15 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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October 28, 2009 1:50:58 PM

Page 2

Item ID: PB67-43001-51

Accept

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1- line drill -89 and -87 using existing pilot hole of -87 as per dwg 2- install spring pin								
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
150 	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3	0.00							
Powdercoat	Memo	0.00							
Powder Coating	***mask prior to powder coat per dwg*** START TIME: 2:30 OVEN TEMPERATURE: 320° FINISH TIME: 3:00								

SP 09 12 15

2) 807/12/15

(16)

09-12-17

D.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 53248**

October 28, 2009 1:50:58 PM



Page 3

Item ID: PB67-43001-51

Accept



Setup Start



Revision ID: C

Stop



Item Name: Long T-Handle Assembly

Start Date: 10/29/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 11/16/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC3- Inspect Part Finish	0.00	09-1217			0	0		
QC Quality Control	Memo	0.00							
170 	Identify as per dwg & Stock Location: _____	0.00							
Packaging Packaging	Memo	0.00							
180 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

C209112121

09/12/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

October 28, 2009 1:48:54 PM

Page 1

Work Order ID: 53248

Parent Item: PB67-43001-51RevC

Parent Item Name: Long T-Handle Assembly


Comments:


Start Date: 10/29/2009

Required Date: 11/16/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
240-107  SPRING SLOTTED PIN		Purchased	No			130	Each	74.0000	1.0000			

✓  SP 09.12.14

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

74

112813

74

PB67-43001-87RevC Manufactured No

100

Each

0.0000

1.0000



Tube Arm

PB67-43001-89RevC Manufactured No

130

Each

0.0000

1.0000



Clevis

PB67-43001-91RevC Manufactured No

100

Each

0.0000

1.0000



Tube Handle

PB67-43001-93RevB1 Manufactured No

100

Each

26.0000

2.0000



Tube End Cap

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

26

40074

2

41520

24

1x

SP 09.12.14

SP 09.12.14

SP 4/5/9

09.12.14

SP 09.12.14

2x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Item Name: Long T-Handle Assembly

Draw Nbr: B67-43001

Start Date: 10/29/2009

Start Qty: 1.00



Revision Nbr: C

Required Date: 11/16/2009

Reqd Qty: 1.00



Reference:

Cust Item ID:

Customer ID:

Description:

Sales Order:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

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			Set Up	Run							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

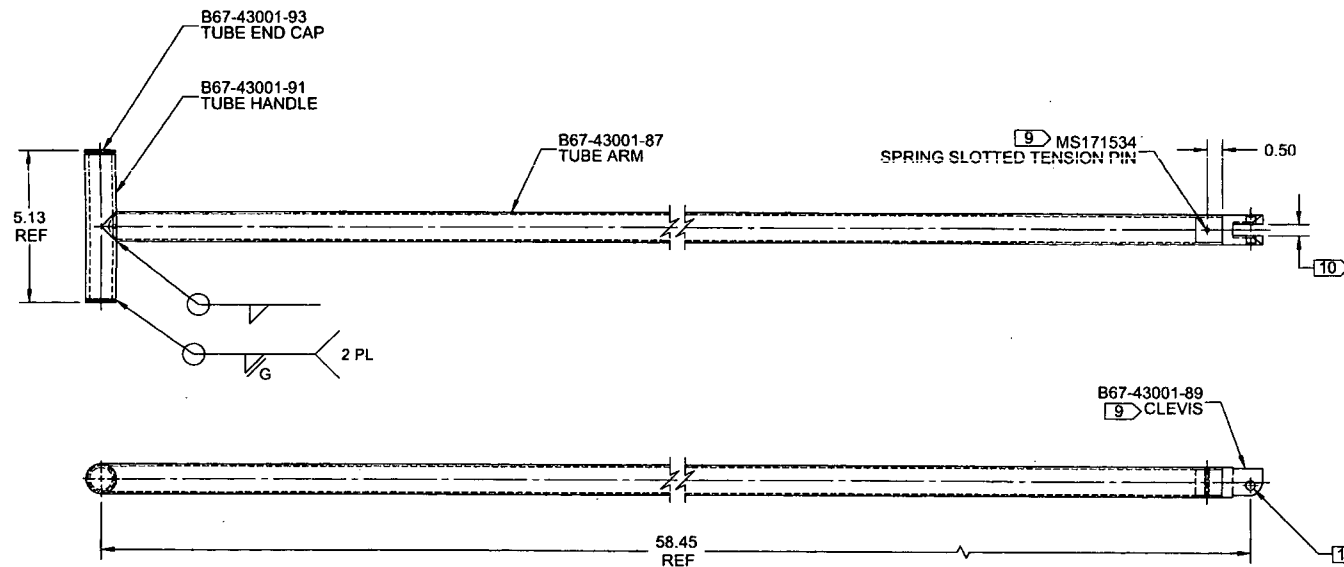
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

ITEM	QTY -19	P/N	DESCRIPTION
1	X	B67-43001-51	LONG T-HANDLE ASSY
3	1	B67-43001-87	TUBE ARM
4	1	B67-43001-89	CLEVIS
5	1	B67-43001-91	TUBE HANDLE
6	2	B67-43001-93	TUBE END CAP
8	1	MS171534	SPRING SLOTTED TENSION PIN (OR 240107)



**B67-43001-51 LONG T-HANDLE ASSY**

**RELEASED**  
2009-09-24

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.35 lbs
- 8) WELDING: PER QSI 004
- 9) PRIOR TO POWDER COAT, ALIGN B67-43001-89 ON B67-43001-87 AS SHOWN AND DRILL A  $\varnothing 0.129$  HOLE THROUGH BOTH PARTS AND FASTEN B67-43001-89 TO B67-43001-87 USING MS171534 SPRING SLOTTED PIN
- 10) MASK PRIOR TO POWDER COAT

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 13 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	09.06.25
REV.	DESCRIPTION	BY	DATE
DESIGN	RW		
DRAWN			
CHECKED	ADS		
MFG. APPR.	AD		
APPROVED	JAD		
DE APPR.	N/A		
DATE	09.06.25		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **B67-43001-51** REV. C  
SHEET 1 OF 1  
TITLE **LONG T-HANDLE ASSY** SCALE NTS

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